

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-010963**Date Inspected:** 30-Dec-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 645**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1845**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Liu Fawen**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Orthotropic Box Girder (OBG) Components**Summary of Items Observed:**

On this date Caltrans Office of Structural Materials Quality Assurance Inspector, Sandeep Kumar (QA) was present during the times noted above for observations relative to the work being performed.

BAY 2

The following Non Destructive Testing (NDT) inspection carried out as per the ZPMC submitted Notification No. 004962

Magnetic Particle Testing (MT)

This QA inspector performed MT of approximately 15% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an MT report for this date. The members are identified as OBG Components. The weld designations reviewed are as follows:

1. FB3007 – 002 – 001~006
2. FB3073 – 002 – 001~006
3. FB3069 – 002 – 001~006

This QA Inspector observed the following work in progress:

Flux Core Arc Welding (FCAW):

Weld joint # 022 located on Longitudinal Diaphragm LD3024 – 001. Welder is identified as 045240. ZPMC Quality Control (QC) Inspector is identified as Zhang Hai Feng. The welding variables recorded by QC appeared

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

to comply with the WPS – B – T – 2132 – 3.

Weld joint # 007 located on Longitudinal Diaphragm LD3023 – 001. Welder is identified as 045209. ZPMC Quality Control (QC) Inspector is identified as Zhang Hai Feng. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2132 – 3.

Weld joint # 018 located on Longitudinal Diaphragm LD3021 – 001. Welder is identified as 045276. ZPMC Quality Control (QC) Inspector is identified as Zhang Hai Feng. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2132 – 3.

BAY 3

This QA Inspector observed the following work in progress:

Flux Core Arc Welding (FCAW):

Weld joint # 007 located on Longitudinal Diaphragm LD3011 – 001. Welder is identified as 208035. ZPMC Quality Control (QC) Inspector is identified as Guo Yuan Ting. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2132 – 3.

Weld joint # 021 located on Cross Beam CB202G – 042. Welder is identified as 204338. ZPMC Quality Control (QC) Inspector is identified as Guo Yuan Ting. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2133.

Shielded Metal Arc Welding (SMAW):

Weld joint # 140 located on Cross Beam CB202G – 041. Welder is identified as 051359. ZPMC Quality Control (QC) Inspector is identified as Guo Yuan Ting. The welding variables recorded by QC appeared to comply with the WPS – B – P – 2113.

BAY 5

This QA Inspector observed the following work in progress:

Flux Core Arc Welding (FCAW):

Repair welding of weld joint # 014 located on Traveler Rail 11TR1 – 028. Welder is identified as 215185. ZPMC Quality Control (QC) Inspector is identified as Zhong Chong Biao. The welding variables recorded by QC appeared to comply with the WPS – 345 – FCAW – 2G (2F) – Repair – 1.

Repair welding of weld joint # 014 located on Traveler Rail 11TR1 – 024. Welder is identified as 215250. ZPMC Quality Control (QC) Inspector is identified as Zhong Chong Biao. The welding variables recorded by QC appeared to comply with the WPS – 345 – FCAW – 2G (2F) – Repair – 1.

Repair welding of weld joint # 014 located on Traveler Rail 10TR4 – 001. Welder is identified as 205390. ZPMC Quality Control (QC) Inspector is identified as Zhong Chong Biao. The welding variables recorded by QC appeared to comply with the WPS – 345 – FCAW – 2G (2F) – Repair – 1.

WELDING INSPECTION REPORT

(Continued Page 3 of 3)

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

Summary of Conversations:

No Relevant Conversations.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang - 15000422372, who represents the Office of Structural Materials for your project.

Inspected By:	Kumar,Sandeep	Quality Assurance Inspector
Reviewed By:	Hall,Steven	QA Reviewer
